

Press Brakes

WAC 296-806-465

Summary

If your specific machine or operation isn't listed here, then follow any general requirements in this section along with the "Requirements for All Machines" found in this chapter, WAC 296-806-200 and WAC 296-806-300.

This section applies to all machines classified as power press brakes. Power press brakes use a ram and bed to bend material.

YOUR RESPONSIBILITY:

To protect employees from hazards associated with power press brakes

You must

GENERAL REQUIREMENTS FOR PRESS BRAKES

Provide auxiliary safety aids	
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Safeguard the point of operation on press brakes	
WAC 296-806-46504	465-3

SAFE DISTANCE SAFEGUARDING

Follow this requirement when using safe distance safeguarding	
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Develop a safe distance safeguarding program	
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Follow these requirements for safe distance training	
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Summary

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Rule

GENERAL REQUIREMENTS FOR PRESS BRAKES

WAC 296-806-46502

Provide auxiliary safety aids on press brakes

IMPORTANT:

This rule applies if the safeguarding method prevents the operator from holding the workpiece during the closing of the stroke.

You must

- Provide one of the following auxiliary safety aids that will allow operators to remove their hands from the work during the closing of the stroke:
 - Work supporting devices
 - Magnetic material-position gages

WAC 296-806-46504

Safeguard the point of operation on press brakes

You must

- Safeguard the point of operation on press brakes by at least one of the following:
 - Physical guards
 - Devices
 - ¼ inch maximum die opening

-Continued-

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Rule

WAC 296-806-46504 (Continued)

- Safe Distance Safeguarding if **all** of the following apply:
 - Physical barriers and devices such as two-hand controls, holdouts, restraints, and presence sensors, are demonstrated to not be feasible.
 - This safeguarding method is only for one-time fabrication, custom-made parts, or small quantity runs of no more than 4 hours per month.
 - A safety program is provided that includes safe work procedures, training, and supervision to make sure work is performed using safe distance measures
 - There is no workplace record of injuries from failing to maintain a safe distance.

SAFE DISTANCE SAFEGUARDING

WAC 296-806-46506

Follow this requirement when using safe distance safeguarding

You must

- Make sure employees position themselves no closer than necessary and never closer than 4 inches from the power press brake point of operation.



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Rule

WAC 296-806-46508

Develop a safe distance safeguarding program for press brakes

You must

- Develop, document, and use an effective safe distance safeguarding program
 - Include methods for maintaining the minimum safe distance requirements in
Follow this requirement when using safe distance safeguarding,
WAC 296-806-46506.

WAC 296-806-46510

Follow these requirements for safe distance training for press brakes

You must

- 1) Train your employees in the safe distance safeguarding program and include **all** of the following:
 - The need for safety awareness between the power press brake operator and, when required, the helper.
 - The purpose and function of operating controls, operating mode controls, die space height adjustment positions, and other brake controls.
 - The hazards of placing any parts of the body into the point of operation
 - The hazards related to each specific workpiece bending operation
 - The purpose and function of hand-feeding tools
 - The dangers of unsafe work practices, inattention, horseplay, and misuse of equipment
 - The importance of reporting unsafe conditions immediately to the supervisor

-Continued-



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Rule

WAC 296-806-46510 (Continued)

You must

- 2) Make sure employees are proficient in safe distance safeguarding after training, and follow both:
 - Safe-operating instructions and recommendations of power press brake manufacturers
 - and**
 - Industry-recognized safe working practices for power press brakes

WAC 296-806-46512

Require safe distance retraining for press brake operations

You must

- 1) Require safe distance retraining when employees either:
 - Are seen operating the power press brake in an unsafe manner
 - or**
 - Fail to use safe distance procedures.
- 2) Require safe distance retraining when conditions in the workplace change that can affect safe operation of the power press brakes, such as introducing new or revised control methods and procedures.



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Rule

WAC 296-806-46514

Conduct periodic safe distance inspections on press brakes

You must

- 1) Conduct periodic inspections of safe distance procedures at least annually to make sure that established procedures are being followed.
- 2) Make sure inspections are performed by a trained person who is **not** the person using the safe distance procedure.
- 3) You must identify **all** of the following during safe distance procedure inspections:
 - The date of the inspection
 - The person performing the inspection
 - The power press brake for which you are using the procedures
 - Any deviations or inadequacies with procedures and requirements.
 - Joint reviews with each trained employee about their responsibilities under the safe distance program.

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Rule

WAC 296-806-46516

Supervise the safe distance program for press brakes

You must

- Provide adequate supervision to make sure that:
 - Only trained employees operate power press brakes
 - Employees use work practices learned in your training program
 - Periodic safe distance inspections are conducted as outlined in, Conduct periodic safe distance inspections on press brakes, WAC 296-806-46514
 - Any deviations from, or inadequacies in, program procedures or work practices are promptly corrected
 - Designated safeguarding means are used, installed, and functioning properly
 - Recommended hand-feeding tools are used, when needed
 - To require retraining and other appropriate corrective action when necessary.

